

# Work Order ID 67064

Monday, March 07, 2011 12:31:45 PM

Page 1

Item ID: D3137-3

Revision ID:

Item Name: Guide

Start Date: 3/7/2011

Start Qty: 30.00

Required Date: 3/11/2011

Req'd Qty: 30.00

Accept

Cust Item ID:

Customer:

Reference:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

ID/ Enter ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
or	Revision Nbr								
D3137	Rev F								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks.Blank size: 1.250" x .750" x .950" long

SL 11/03/09

40

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA242 & Dwg D3137-2-Deburr

SL 11/03/09

40

120

0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

SL 11/03/09

40

# Work Order ID 67064

Monday, March 07, 2011 12:31:45 PM



Page 2

Item ID: D3137-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 3/7/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



*11/03/09*

QC

Memo

0.00

Quality Control

*40*

140

Identify as per dwg & Stock Location: *235B*

0.00



Packaging

Memo

0.00

Packaging

*11/13/10* *(40)*

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



*11/3/10*

*11-03-10* *(40)*

# Picklist Print

Monday, March 07, 2011 12:31:42 PM

Page 1

Work Order ID: 67064

Parent Item: D3137-3

Parent Item Name: Guide



Start Date: 3/7/2011

Required Date: 3/11/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 02.05.29 New Issue NG  
IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC  
IPP Rev c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Status
MDELRLNB0.75X1.250		Purchased	No			100	f	15.9339	0.0791	2.497895		
Delrin Bar												

Location

Loc Qty

Loc Code

MAT050

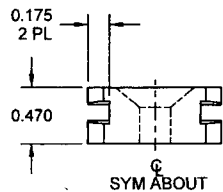
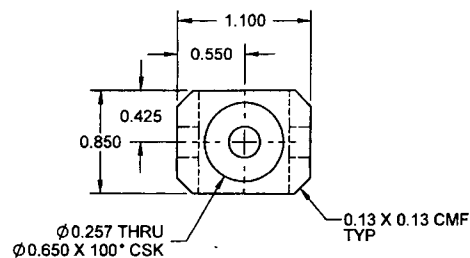
15.9339

14535

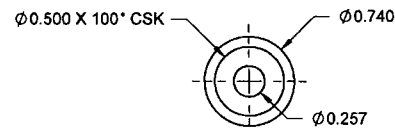
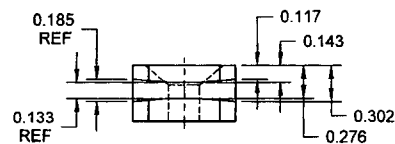
15.9339

2 11/03/07

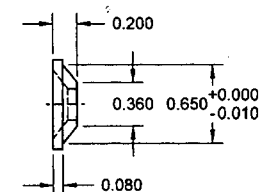
3.75



**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

*W/O 67004*

**RELEASED**

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

